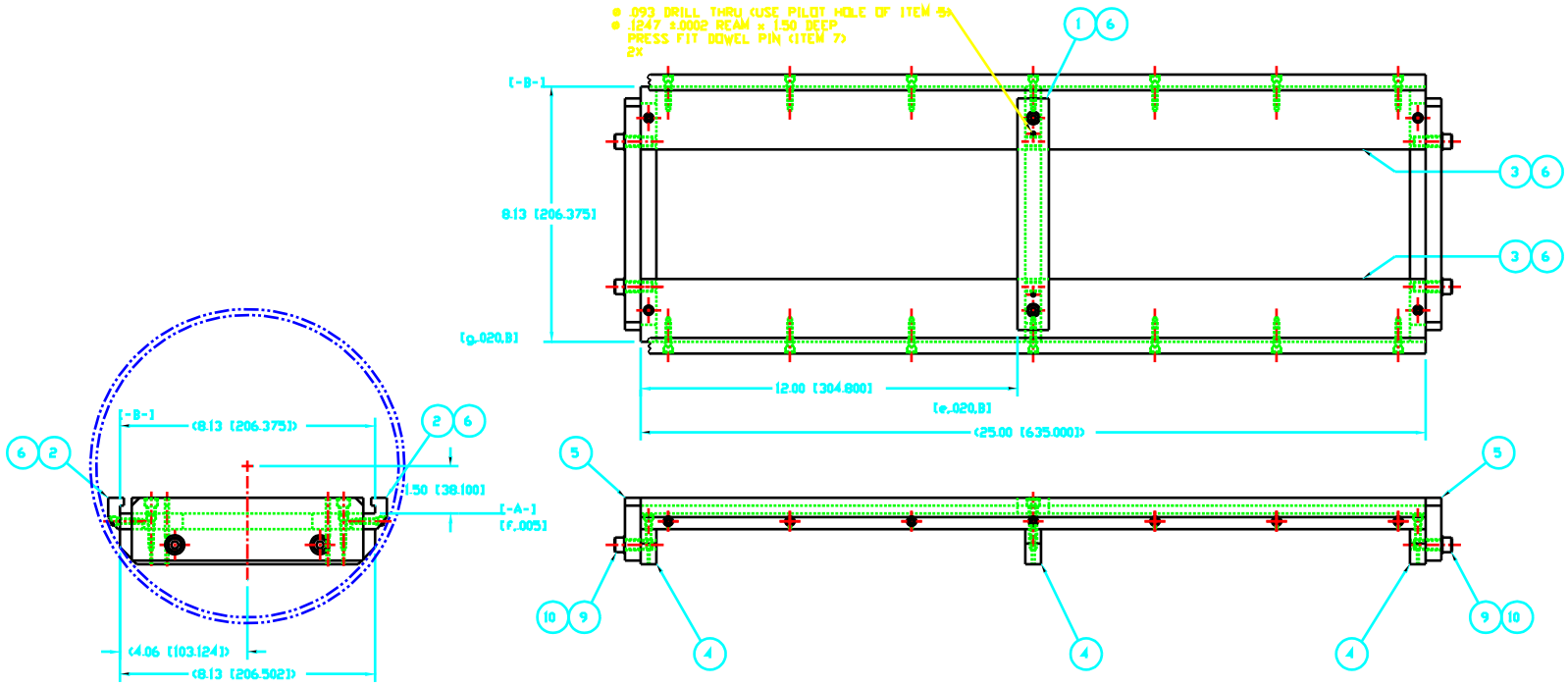

NOTE:
1. THIS IS A ULTRA-HIGH VACUUM COMPONENT (UHV).
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
   A) CINCOOL 5 STAR 49
   B) TRIM SOL
3. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

PARTS LIST

ITEM	DWG & ELECTRONIC FILE NO	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
10		LOCKWASHER, EXTERNAL TOOTH .33 I.D. x .61 O.D. x .03 THK.	SST	4
9		SCREW, SOCKET HEAD CAP VENTED 5/16-18 UNC-3A x .88 LG.	SST SILVER PLATED	4
8		DOWEL PIN VENTED ● .125 x 1.00 LG.	SST SILVER PLATED	2
7		SCREW, SOCKET HEAD CAP VENTED 1/4-20 UNC-3A x 1.00 LG.	SST SILVER PLATED	2
6		SCREW, SOCKET HEAD CAP #8-32 UNC-3A x .63 LG.	SST SILVER PLATED	18
5	P4102020105-210105-00	S2 END PLATE	SST 304	2
4	P4102020105-210104-00	S2 RIB BAR	SST 304	3
3	P4102010108-210102	S1 SLIDE BAR	SST 304	2
2	P4102010102-210103	S1 CLAMP BAR	SST 304	2
1	P4102020105-210101-00	S2 STOP BAR	SST 304	1

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS

UNLESS DIMENSIONS SPECIFIED ALL DIMENSIONS ARE IN INCHES
DECIMALS: .X ± .020, .XX ± .010, .XXX ± .005
ANGLES ± 0.25°
SURFACE ROUGHNESS 125√
REMOVE ALL BURRS AND SHARP EDGES
MATERIAL SHALL BE FREE OF ALL FOREIGN MATERIAL
MINIMUM SURFACE ROUGHNESS TO BE 125 RMS
MINIMUM SURFACE TREATMENT TO BE ALL SURFACES TO BE CLEAN AND FREE OF ALL FOREIGN MATERIAL
DO NOT SCALE DRAWING

ELECTRONIC FILE NUMBER A09942

DRAWN BY RICK KRAKORA 4/93
CHECKED BY
DESIGNED
ENGINEERING CHANGES
CHIEF DESIGN ENGINEER
CP LEADER
PROJECT MGR
APPROVED/CONTROLLED

MATERIAL SEE B.O.M.

SCALE 1=2 SHEET 1 of 1 SIZE D

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TITLE ADVANCED PHOTON SOURCE
S2 B.M. SAFETY SHUTTER RAIL ASSEMBLY

DRAWING NUMBER P4102020105-210100-00

PLOT SCALE:1=2